

Work Order ID 74786 - 2

\*74786\*

Page 1

October 6, 2011 1:36:52 PM

Item ID: D412-630-033

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli Access Step LH Folding

Start Date: 10/06/11 Start Qty: 400

\*4\*

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 400

\*4\*

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 11/10/08 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M119317

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114596

Signature: 11/11/30 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 74786

**\*74786\***

Page 2

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Item ID: D412-630-033

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli Access Step LH Folding

Stop **\*NS2\***

Start Date: 10/06/11 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

**\*140\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start \*NS1\*

Revision ID:

Item Name: Heli Access Step LH Folding

Stop \*NS2\*

Start Date: 10/06/11 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
*150*	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: _____								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

*Levy/2/20*

*11/12/21*

*MF 11-12-2021*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 74786

\*74786\*

Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn 1019, added d2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107

Manufactured

No

110

Each

15.0000

1

4

\*D2012-107\*

Clevis

\*\*

SP

Location

Loc Qty

Loc Code

ST004

15

71602

15

D2803-041

Manufactured

No

110

Each

1.0000

1

4

\*D2803-041\*

Bracket Assembly

\*\*

4X  
B 74804 SP

Location

Loc Qty

Loc Code

ST147

1

71560

1

D2804-041

Manufactured

No

110

Each

4.0000

1

4

\*D2804-041\*

Bracket Assembly

\*\*

1X  
SP 11-11-29

Location

Loc Qty

Loc Code

ST148

4

71561

4

4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D2807-041

Manufactured No

110

Each

45.0000

2

8

\*D2807-041\*

Door prop

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST022

40

60540

2

71562

3

73030

10

73920

25

ST023

5

68494

5

3x

5x

D2813

Manufactured No

110

Each

13.0000

2

8

\*D2813\*

Washer

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST023

13

69386

1

71169

12

8x

D3562-041

Manufactured No

110

Each

0.0000

1

4

\*D3562-041\*

Step Assembly, LH

D3395-1

Manufactured No

110

Each

65.0000

4

16

## Location

## Loc Qty

## Loc Code

ST052

65

70775

2

71563

63

6x

10x

\*D3395-1\*

Bushing

\*\*

SP

B 74788 (4x)

SP 11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

AN3C21A  
\*AN3C21A\*  
BOLT

Purchased No

110 Each 52.0000 2 8

\*\*

~~m 117514~~  
m 117366 1x 8P

Location Loc Qty Loc Code

ST352 52

109148 2

117514 50

7x

AN8C16  
\*AN8C16\*  
Bolt

Purchased No

110 Each 22.0000 2 8

\*\*

m 119324 8P  
31

Location Loc Qty Loc Code

ST345 22

106066 7

118451 15

5x

AN310C8  
\*AN310C8\*  
Nut

Purchased No

110 Each 28.0000 2 8

\*\*

8P

Location Loc Qty Loc Code

ST324 28

118091 8

118378 20

8x

MS24665-302  
\*MS24665-302\*  
Cotter Pin

Purchased No

110 Each 115.0000 6 24

\*\*

8P 11-11-29

Location Loc Qty Loc Code

ST357 115

117460 115

24x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

\*74786\*

\*D412-630-033\*

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

115.0000

4

16

\*NAS1515H3\*

Washer

\*\*

SP

Location

Loc Qty

Loc Code

ST277

115

116373

6

118078

6

118384

103

16x

NAS1515H5L

Purchased

No

110

Each

128.0000

4

16

\*NAS1515H5I \*

WASHER

\*\*

M 119309 SP.2x

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

88

111359

4

118614

84

118614 14x

NAS1515H8

Purchased

No

110

Each

171.0000

4

16

\*NAS1515H8\*

Washer

\*\*

SP 11-11-29

Location

Loc Qty

Loc Code

ST278

171

111275

4

111411

167

16x



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

951.0000

4

16

\*MS21043-3\*

Nut

\*\*

SP

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

879

118077

1

118614

492

118686

386

mouse 110

Each

63.0000

2

8

MS24693-C280

Purchased

No

\*MS24693-C280\*

Screw

\*\*

SP

11-11-29

Location

Loc Qty

Loc Code

ST310

62

118093

12

118612

50

ST318

1

111279

1

D2806-1

Manufactured

No

\*D2806-1\*

Bushing

130

Each

18.0000

2

8

\*\*

B75047 SP 2x  
72141 6x

Location

Loc Qty

Loc Code

ST022

18

72141

18

October 6, 2011 1:36:57 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 74786

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Parent Item: D412-630-033

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Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D2806-3

Manufactured No

130

Each

19.0000

2 8

\*D2806-3\*

Bushing

\*\*

B 75046 SP

Location

Loc Qty

Loc Code

ST022

19

70886

1

72138

18

72138 70

D2810-5

Manufactured No

130

Each

7.0000

1 4

\*D2810-5\*

Strut

\*\*

75077

Location

Loc Qty

Loc Code

ST265

7

52034

1

71564

6

D3396-1

Manufactured No

130

Each

12.0000

2 8

\*D3396-1\*

Spacer

\*\*

75049

Location

Loc Qty

Loc Code

ST052

12

69906

12

AN4C6A

Purchased No

130

Each

242.0000

1 4

\*AN4C6A\*

Bolt

\*\*

11/14/9 (4)

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

238

116704

15

118451

123

118983

100

118983

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4

Purchased

No

130

Each

183.0000

7 28

\*\*

\*NAS1515H4\*

Washer

Location

Loc Qty

Loc Code

ST277

183

116169

3

117460

29

117735

3

118078

48

118612

100

118612

NAS1515H5

Purchased

No

130

Each

163.0000

7 28

\*\*

\*NAS1515H5\*

Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

123

103286

100

118384

23

M108236

MS21043-4

Purchased

No

130

Each

841.0000

4 16

\*\*

\*MS21043-4\*

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

801

117793

301

118686

500

M119309

10/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

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Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

60.0000

1 4  
\*\*

\*AN4C10A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST356

60

112243

30

114523

30

AN5C15A

Purchased

No

130

Each

65.0000

2 8  
\*\*

\*AN5C15A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST338

15

118191

15

ST339

50

118267

50

AN44C7A

Purchased

No

130

Each

52.0000

1 4  
\*\*

\*AN44C7A\*

Eyebolt

## Location

## Loc Qty

## Loc Code

ST362

52

109013

12

111308

40

AN4C15A

Purchased

No

130

Each

129.0000

2 8  
\*\*

\*AN4C15A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST358

129

115835

2

118628

27

118706

100

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

\*74786\*

\*D412-630-033\*

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130 *Sac* Each

424.0000

*3* *12*

\*\*

*Supp Cy*

\*MS21043-5\*

Nut

## Location

## Loc Qty

## Loc Code

FG	20
101418	20
ST301	304
112314	204
116548	100
ST314	100
118159	100

*112314*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

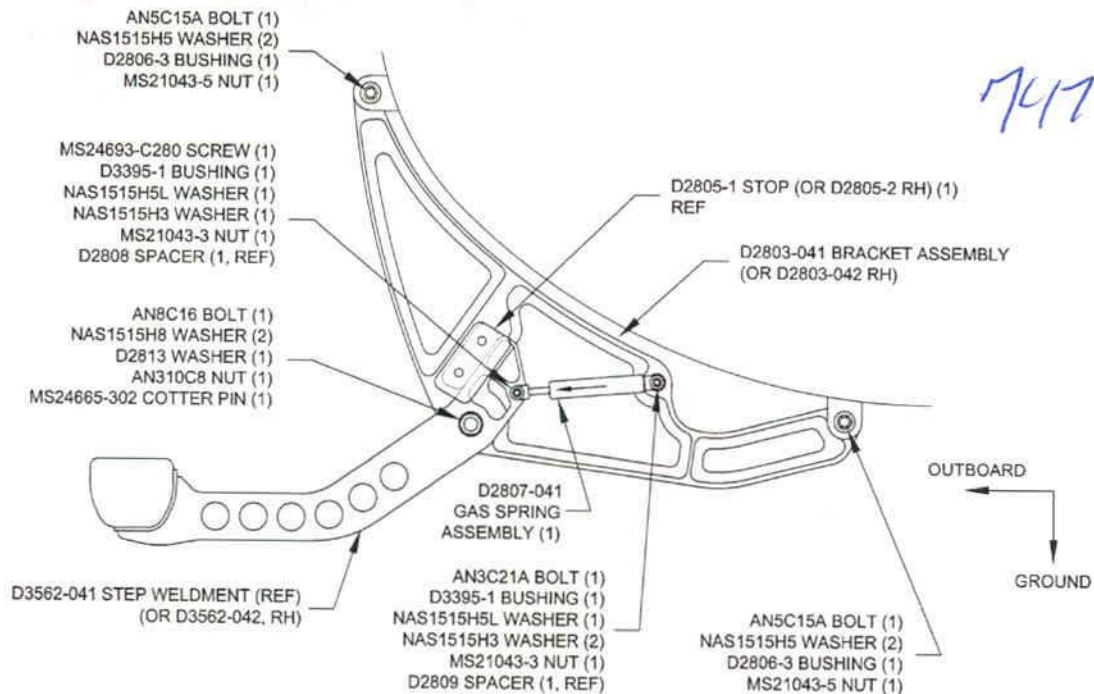
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

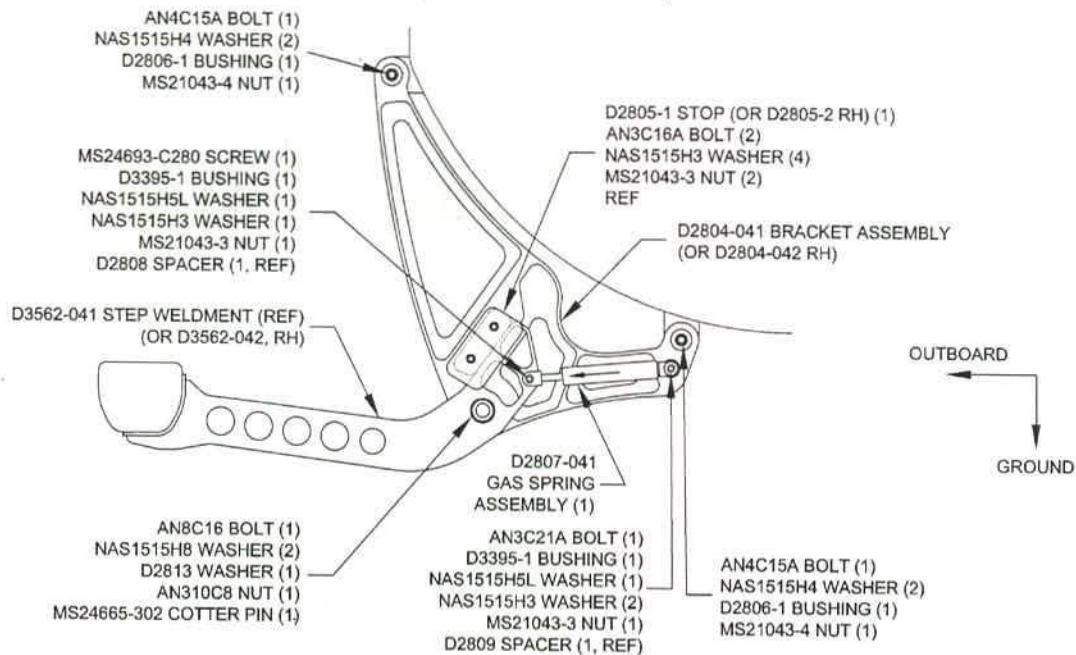
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**NOTE:** Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**



**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

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Revision: **M**  
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

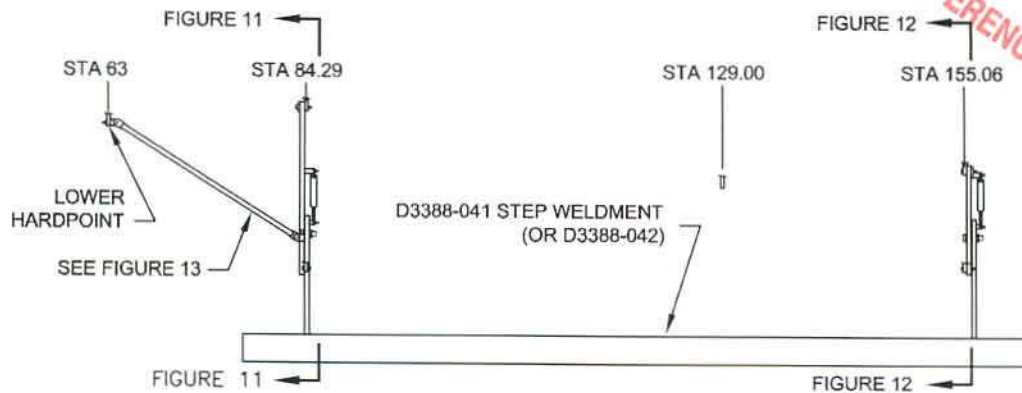
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

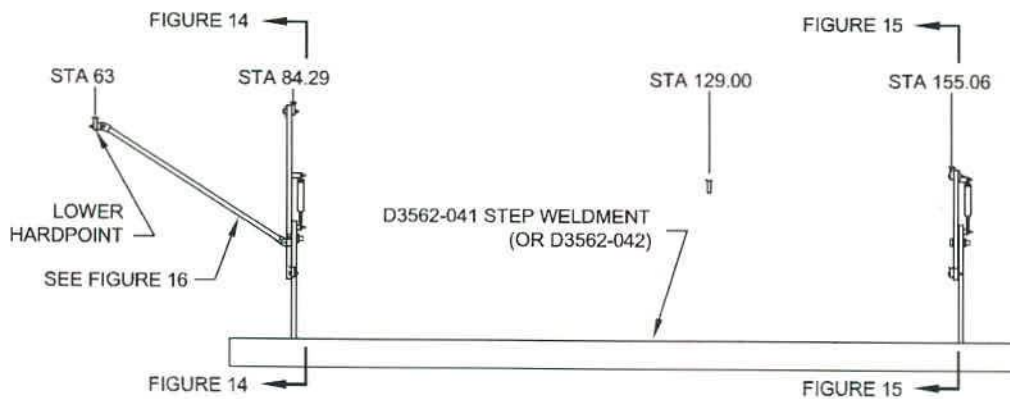
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

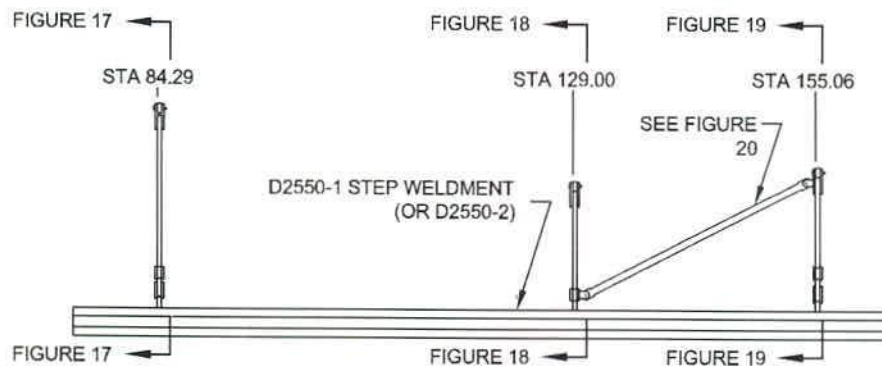
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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